

Work Order ID 68884

Page 1

Monday, April 25, 2011 8:45:32 AM

Item ID: D3748-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half

Start Date: 4/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3748	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3748 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

364.120

B11-4-25

110

0.00



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

QC

Quality Control

B11-4-25

120

0.00



QC8- Inspect parts - second check

Memo

0.00

QC

Quality Control

8464254/6

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Debur if necessary								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3748 using DT9510								

SB 11/04/20

(16)

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Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.164/26

H6

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

11/4/26 SF (16)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27 JF

MF
11-04-26

Picklist Print

Monday, April 25, 2011 8:45:29 AM

Page 1

Work Order ID: 68884



Parent Item: D3748-I



Parent Item Name: Hinge Half

Start Date: 4/25/2011

Required Date: 4/26/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC
IPP Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	192.0000	0.0341	0.215368			
304/316 0.125 Sheet													

5456

11-4-05

M 304B, 125 BAR

X 04.000

Location

MAT020

117494

Loc Qty

192

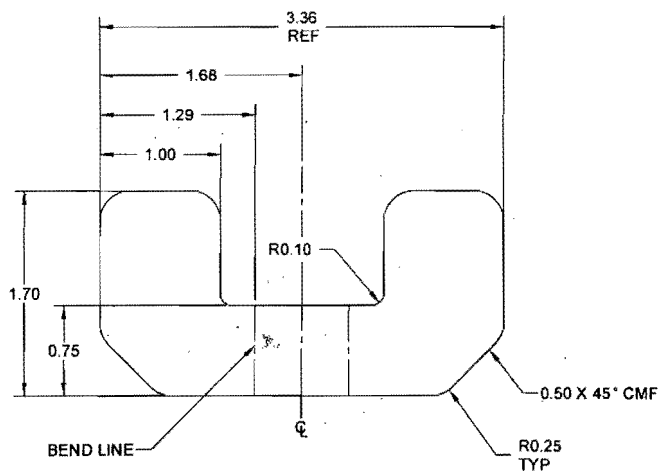
192

Loc Code

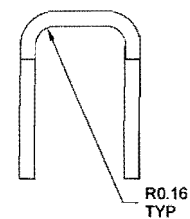
116961

~~11745~~

16



D3748-1F FLAT PATTERN



D3748-1 HINGE HALF

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.15 lbs

A		INITIAL RELEASE		AJS	08.02.05
REV		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3748		SHEET 1 OF 1	
APPROVED		TITLE		SCALE	
DE APPR.		HINGE HALF		1:1	
DATE		COPY RIGHT © 2005 BY DART AEROSPACE LTD			
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